	1
ork Order ID 57955	
V 3 7 8 6 3 4 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	



Page 1

April 21, 2010 8:43:5.	3 AM										
Item ID: D3929 Revision, ID:	9-041		Accept					Setup	Start		
Item Name: Gusset	Assembly								Stop		
Start Date: 21/04/ Required Date: 28/04/				Cust Item I Customer:	D:						
Reference: Approvals: Proc QC:	ess Plan:	Date: 10-4-3/	Tooling: SPC (Y/N):		ite:			Run	Start Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	:		 			(23				Stamp
D3929	Rev A			<u>.</u>			•				· j.
		:	0.00		ī		ID.	ω- ¥	<u>- 26</u>		
FLOW CNC Waterjet	Memo I-Cut as p Dwg Rev: Prog Rev: 2-Deburr i	_ / _	0.00					<u>0: </u>	<u>- 1</u> 6	C)
110 	QC2- Inspect parts off	machine FAI/FAIB	0.00								

Quality Control

Memo

0.00

1B10-4-26

Dart Aerospace Ltd	D	art	Aer	osp	ace	Ltd
--------------------	---	-----	-----	-----	-----	-----

	-									
W/O:			WO	RK ORDER CHANG	GES					35.
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						-				
Part No	:	PAR #:	Fault Categ	ory:	NCR: Y	es N	o DQA	۱:	Date:	
		esolution:								
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC	Initial		tion B		Verific		Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng		gn & ate	Section	on C	Chief Eng	QC Inspector
										·
								į		
										·
					-					

Worl	c Ord	er ID	579	55

April 21, 2010 8:43:53 AM



Page 2

Item ID:

D3929-041

Accept

Setup Start

Stop



Revision ID:

Start Date:

Gusset Assembly Item Name:

21/04/2010 Start Qty: 6.00 **Required Date: 28/04/2010** Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



QC:

Date:

SPC (Y/N):

Date:

Reject

Reject Insp.

Sequence ID/ **Work Center ID**

120

Memo

Set Up/ **Run Hours**

Draw Number

Plan Draw Rev.

Accept Qty Code

Qty

Number Stamp

Quality Control

Memo

QC8- Inspect parts - second check

0.00

0.00

Packaging Packaging

Pick Kit Memo

Operation

Description

0.00

140

Large Fab

Large Fab

0.00

0.00

Weld bushings D3907-1 as per dwg D3929

316L rod | batch: 111679

	•	•								,
W/O:			W	ORK ORDER CHANG	GES					<u> </u>
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										1
			-4.4							
Part No		PAR #:	Fault Cat	egory:	NCR	: Yes I	No DQ	A:	Date: _	
	Re	esolution:	Dispositi	on:	QA:	N/C Clo	sed:		Date:	
NCR:			WORK ORI	DER NON-CONFORM	ANCE	(NCR				
DATE	STEP	Description of NC	Initial		tion B	Sign &		cation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector
										·
						7				

April 21, 2010 8:43:53 AM

Item ID:

D3929-041

Revision ID: Item Name:

Gusset Assembly

Start Date:

21/04/2010

Start Qty: 6.00

Required Date: 28/04/2010

Req'd Qty: 6.00



Accept

Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____ Tooling:

QC: ______ Date: _____ SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/ Work Center ID

150

Quality Control

Operation Description

QC9- Inspect visual per QSI004- Fusion Welds

Memo

Memo

Set Up/ Run Hours

0.00

0.00

Number

 $\sim 1 \cdot 1$

Draw

Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

10.04.29

160

Quality Control

QC5- Inspect part completeness to step on W/O

170

Packaging

Packaging

Identify as per dwg & Stock Location: WA

Memo

SAD 0.00 10-04-30

W/O:			W	ORK ORDER C	HANGES	<u>, </u>				
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			a .							
		·								
Part No	:	PAR #:	Fault Ca	tegory:	NCI	R: Yes I	No DQ	٨:	Date:	
	R	esolution:	Dispositi	ion:	QA	N/C Clo	sed:		Date:	
NCR:		\	WORK ORI	DER NON-CONF	ORMANCE	(NCR)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Action Description	ription	Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		Date				
					i					
									3	

Work Order ID 57955 April 21, 2010 8:43:53 AM Item ID: D3929-041 Accept Setup Start **Revision ID:** Item Name: Gusset Assembly Stop **Start Date:** 21/04/2010 Start Qty: 6.00 **Cust Item ID: Required Date: 28/04/2010 Req'd Qty:** 6.00 **Customer:** Reference: Start Run Process Plan: Approvals: Date: _____ Tooling: Date: Stop OC: Date: _____ SPC (Y/N): Date: __ Sequence ID/ Operation Set Up/ Draw Draw Plan Accept Reject Work Center ID Description

QC21- Final Inspection - Work Order Release

Memo

180

Quality Control

Run Hours

0.00

0.00

Number

Rev.

Code

Qty

Qty

Page 4

Insp.

Stamp

Reject

Number

	-								١
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								,	
Part No	4	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	A :	_ Date: _	
	Res	solution:	Dispositi	on:	_ QA: N/C CI	osed:		Date: _	
NCR:		\	NORK ORE	DER NON-CONFORMA	NCE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section		Chief Eng	QC Inspector

Picklist Print

April 21, 2010 8:43:57 AM

Work Order ID: 57955

Parent Item:

D3929-041

Parent Item Name: Gusset Assembly

Comments:



Start Date: 21/04/2010

Required Date: 28/04/2010

Page 1

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	14.2200	2.8421			<u>:</u>
304/316, 0.125 Sheet											B10-4-21	_

304/316 0.125 Sheet

Warehouse Loc Oty Location

Main Warehouse

MAT19

112663

14.22

14.22

31.0000 12.0000

Loc Code

112663

D3907-1 Bushing 1

Manufactured

130

Each

Loc Oty Warehouse Loc Code Location Main Warehouse WA 31 57242 31

	•									*1
W/O:			WC	RK ORDER CHANG	GES					·
DATE	STEP	PRO	CEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							. 1			
Part No	•	PAR #:	Fault Cate	jory:	_ NCF	R: Yes I	lo DQ	A :	_ Date:	
·-	R	esolution:	Disposition	n:	QA:	N/C Clo	sed:		Date:	
NCR:		·	VORK ORDE	R NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC			tion B		Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
		·								
	· .									
	: :									
-										
									·	

DART AEROSPACE LTD	Work Order:	579.55
Description: Support Gusset	Part Number:	D3929-1
Inspection Dwg: D3929 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+0.006/-0.001	.379	8			
0.500	+/-0.010	:500	~		11	
0.500	+/-0.010	. 500	>			
4.036	+/-0.010	4.038	4			
4.382	+/-0.010	4,383	خ			
8.274	+/-0.010 ·	8.275	L			·
10.915	+/-0.010	10.915	8			
1.000	+/-0.010	1.006	×			
11.198	+/-0.010	11.198				
0.500	+/-0.010	.500	يعظ			
1.572	+/-0.010	1.574				
0.125	+/-0.010	118	Z			
		·				
			, and the second			
			·-			
						7
				,		

Measured by:	B	Audited by:	7	1		Prototype Approval:	N/A
Date:	10476	Date:	6)	sloy	24	Date:	N/A

Rev	Date	Change		Revis	ed	þу	Approved
Α	09.05.27	New Issue	P/O D3929-041/-042	KJ	o	1_	12
					$\overline{}$,	

W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date Qty Appro-			Approva	
			· · · · · · · · · · · · · · · · · · ·	· ·						
]									
				<u> </u>						
Part No	:	PAR #:	Fault Cated	jory:	_ NCR: Yes	No DQ	A:	Date: _		
	Re	esolution:	Disposition):	QA: N/C (Closed:		Date: _		
NCR:		· · · · · · · · · · · · · · · · · · ·	WORK ORDE	R NON-CONFORM	ANCE (NC	R)				
DATE	STEP Description of NC			ion B	Verifi	cation	Approval	Approval		
	0121	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		tion C	Chief Eng	QC Inspector	
1	1	t .	1 1		ı	i i		1		

D3929-042 GUSSET ASSEMBLY

QTY -041 ITEM DESCRIPTION D3929-041 D3929-042 GUSSET ASSEMBLY
GUSSET ASSEMBLY BUSHING SUPPORT GUSSET D3907-1

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER NO. 57955 BS10-4-21

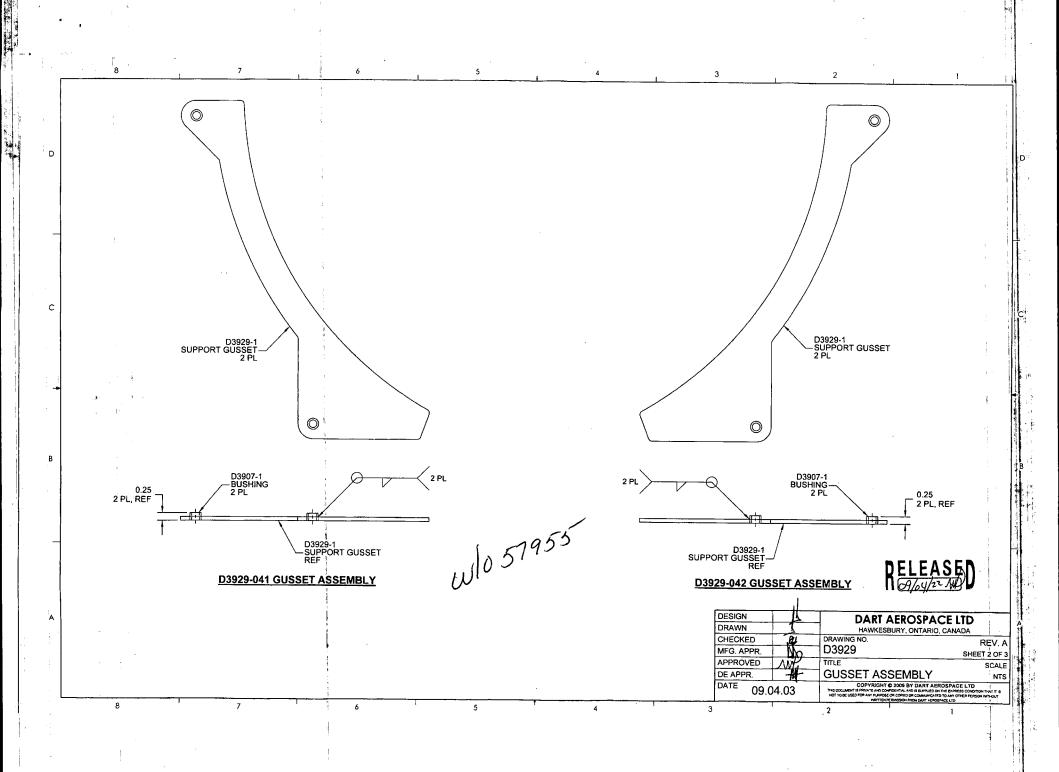
					j.				
Α	NEW IS	мв	09.04.03						
REV.	DESCRIPTION BY								
DESIGN		4	DART AEROSPA	CFI	TD				
DRAWN	Ī	25	HAWKESBURY, ONTARIO						
CHECK	ED		REV. A						
MFG. AF	PPR.	W	D3929		SHEET 1 OF 3				
APPROV	√ED	NA(I)	TITLE		SCALE				
DE APP	R.	4	GUSSET ASSEMBLY	GUSSET ASSEMBLY					
DATE	09.0	4.03	COPYRIGHT © 2009 BY DART AE THIS DOCUMENT IS PRIVATE AND CONTIDENTIAL AND IS SUPPLIED O	ROSPACI	E LTD				

D3929-041 GUSSET ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.73 lbs FACH

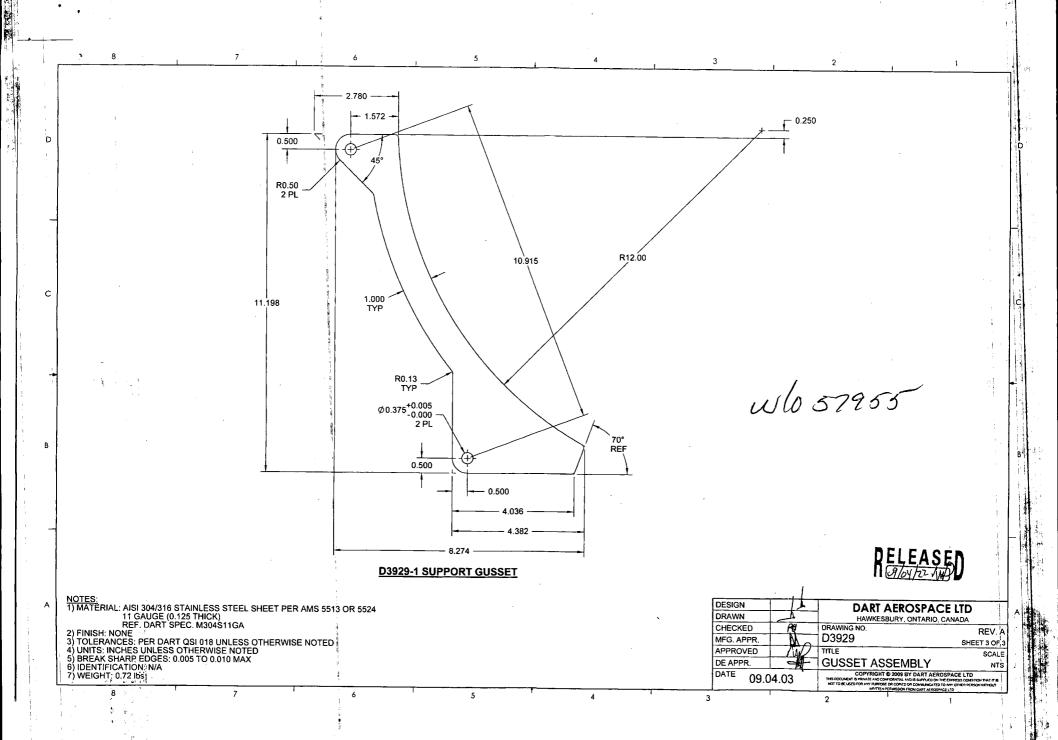
7) WEIGHT: 0.73 lbs EACH 8) WELDING: PER DART QSI 004

W/O:			W	ORK ORDER CHANG	GES				······································	
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					·					
Part No	:	PAR #:	Fault Cate	egory:	_ NCI	R: Yes I	No DQ	٠ ٨ :	Date:	
				Disposition: QA: N/C Closed:						
NCR:		1	WORK ORDER NON-CONFORM							1
DATE	STEP Description of NC		Corrective Action Section B			Verifica			Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector
								٠		
		,								
									,	
				·						
										-



	Dart	Aer	osi	oace	Ltd
--	------	-----	-----	------	-----

	•									
W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									·	
Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQ /	A:	Date:	
	Re	esolution:	Disposition	1:	_ QA: N	I/C Clo	sed:		Date:	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)				
DATE	STEP Description of NC		Corrective Action Se				Verific	ation	Approval	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	,	Sign & Date	Section	on C	Chief Eng	QC Inspector
								,		
									-	
										·
	1 1		1				1		l	I



	-									
W/O:			W	ORK ORDER CHAN	GES					
DATE	STEP	PR	OCEDURE CHA	NGE		Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							·			

Part No	•	PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQA	\:	_ Date: _	
	Res	olution:	Dispositio	n:	QA: N	I/C Clos	sed:		Date:	
NCR:			WORK ORD	ER NON-CONFORM	IANCE (NCR)				
DATE	STEP Description of NC		In its at	ction B	Verification		Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	n C	Chief Eng	QC Inspector
				,						,
	1 1		i l		1		i			l